

ASAP

Dart Aerospace Ltd.

Date: Friday, 22/06/2007 7:18:18 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 33100		
Estimate Number	: 10383		
P.O. Number	: <u>N/A</u>	Part Number	: D30661
This Issue	: 22/06/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3066 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 32585	Material	: <u>N/A</u>
Written By	: _____	Due Date	: 29/06/2007
Checked & Approved By	: _____	Qty:	100 Um: Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0992 sf(s)/Unit Total : 9.9225 sf(s)
 Material: 6061-T6 0.080" thick
 (M6061T6S.080)
 Batch: M103961

SAD 07/06/23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3066
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

SAD 07/06/25/100

SAD

07/06/23

100

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/06/23

100

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/06/25

Count 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/2016
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/06/2007 7:18:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 33100

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



100X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.A 07/06/25

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

100 07-06-26

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W194

100 07-06-26

8.0

QC21

FINAL INSPECTION/W/O RELEASE



100

Comment: FINAL INSPECTION/W/O RELEASE

07/06/26

Job Completion



07/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

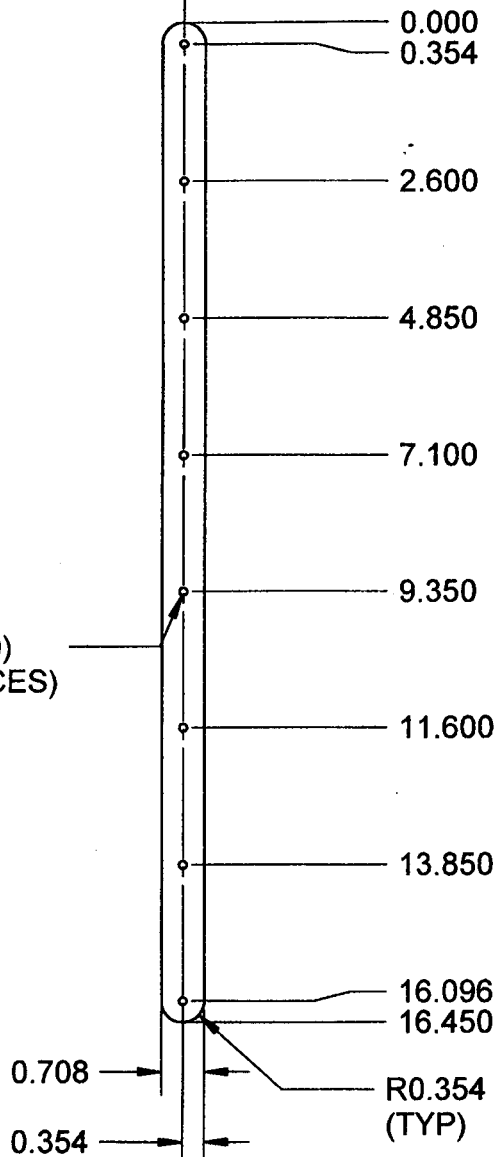
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*de. de. 20* *[Signature]*

$\phi 0.128$ (#30)
(TYP 8 PLACES)

**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 33100
Description: SPACER		Part Number: D30661
Inspection Dwg: D30661 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.354	± 0.010	0.351	✓		Vern	
B	2.600	± 0.010	2.609	✓		Vern	
C	4.850	± 0.010	4.850	✓		Vern	
D	7.100	± 0.010	7.100	✓		Vern	
E	9.350	± 0.010	9.352	✓		Vern	
F	11.600	± 0.010	11.594	✓		Vern	
G	13.850	± 0.010	13.850	✓		M-T	
H	16.096	± 0.010	16.095	✓		M-T/Vern	
I	16.450	± 0.010	16.450	✓		M-T/Vern	
J	0.708	± 0.010	0.706	✓		Vern	
K	0.354	± 0.010	0.352	✓		Vern	
L	Ø 0.128	$\frac{+0.005}{-0.004}$	Ø 0.130	✓		Vern	
M	0.080	± 0.010	0.080	✓		Vern	
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 07/06/23	Date: 07/06/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	